

Date:
User:Tuesday, 4/25/2006 7:35:26 AM
Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STRUT
Job Number	: 26792		
Estimate Number	: 11557		
P.O. Number	: N/A	Part Number	: D30841
This Issue	: 4/25/2006 S.O. No. : N/A	Drawing Number	: D3084 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	: N/A	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 5/5/2006
Checked & Approved By	: <u>06.04.25</u>	Qty:	6 Um: Each
Comment	: Est. 02.05.11 Added welding rod batch number NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6T0750W058	6061-T6 Tube .750 x.058W
Comment: Qty.: 3.3249 f(s)/Unit Total: 19.9496 f(s) 6061-T6 Tube .750 x.058W Material: .750 Dia X .058 wall 6061-T6(ww-t-700/6)Seamless Aluminum tubing No: <u>1710099</u>		
		Batch <u>FF 06.05.16</u>
2.0	BAND SAW	BAND SAW
Comment: BAND SAW Punch per Dwg. D3084 and spec control dwg D2638 Open hole to .3230 as per dwg, one side only Deburr		
		<u>FF 06.05.16</u>
3.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		
		<u>SB 06/05/24</u>
4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1 Weld ends per QSI 004. Use aluminum rod Grind flush Batch: <u>M/8838</u>		
		<u>06/05/24 (6)</u>
5.0	QC5/9	WELD INSPECTION
Comment: WELD INSPECTION		
		<u>PD 06-05-24 (6)</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: LP Date: 06/05/26
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STRUT

Job Number: 26792

Part Number: D30841

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Seq. #:	Machine Or Operation:	Description :
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6.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-05-25

(6)

7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

AR 06/05/25

(6)

8.0	PACKAGING 1	PACKAGING RESOURCE #1
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ST122



Comment: PACKAGING RESOURCE #1

AR 06/05/25

(6)

9.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

06/05/26

(6)

Job Completion



06-05-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

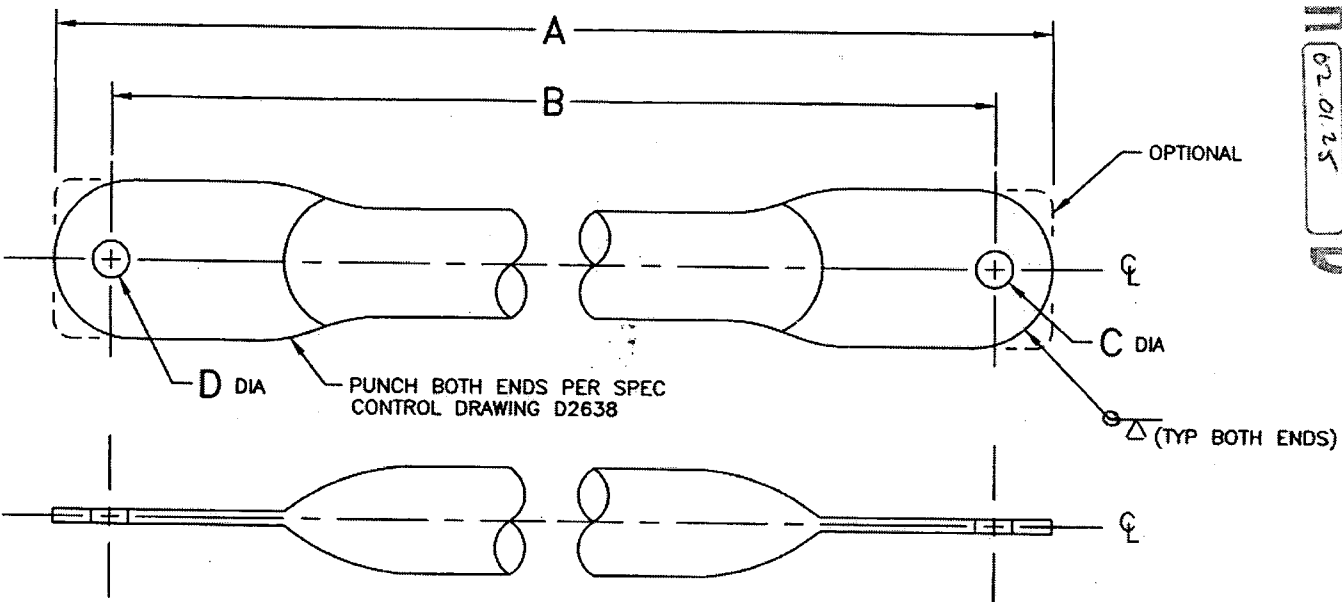
NOTE: Date & initial all entries

DART



DESIGN		DRAWN BY <i>CP</i>		DART AEROSPACE LTD	
CHECKED <i>#</i>		APPROVED <i>#</i>		HAWKESBURY, ONTARIO, CANADA	
DATE		DRAWING NO.		REV. A	
02.01.21		D3084		SHEET 1 OF 1	
TITLE		STRUT		SCALE	
A		02.01.21		NTS	
NEW ISSUE					

RELEASED
02.01.25



	A	B	C	D
D3084-1	37.18	36.38	0.257	0.323

NOTES:

1. MAKE PER TEMPLATE DT3084-XX WHERE XX IS THE RESPECTIVE DASH NUMBER
2. MATERIAL: 6061-T6 (WW-T-700/6) SEAMLESS TUBE $\phi 0.750 \times 0.058$ WALL
3. WELD ENDS PER DART QSI 004 AND GRIND FLUSH
4. FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
5. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6. ALL DIMENSIONS ARE IN INCHES

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WORK ORDER
26792

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